

Work Order ID 58148

April 26, 2010 1:36:05 PM

Page 1

PRELIMINARY ISSUE

Item ID: D3262-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 4/26/10

Start Qty: 1.00

Cust Item ID:

Required Date: 4/27/10

Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3262

DE

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

MMW  
10/04/26

1 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per dwg D3262  
Machine as per Folio FA902 and Dwg D3262  
FOLIO REV: AA  
DWG REV: D  
Deburr

10/04/27

1

# Work Order ID 58148

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Page 2

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 4/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*DTT*  
*6/04/27*

*1*

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*ATA*  
*Test only*  
*9/10-04-27*

*①*

140

Identify as per dwg & Stock Location: *LG*

0.00



Packaging

Memo

0.00

Packaging

*①*

*BE 10/04/29*

# Work Order ID 58148

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Page 3

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 4/26/10

Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL  
EFFECTIVE 4/24/12 AUTH

RELEASED

DATE 10/05/12

see new spec  
attached released  
05/07

10/05/12  
R80-429  
①

# Picklist Print

April 26, 2010 1:36:05 PM

Page 1

Work Order ID: 58148



Parent Item: D3262-5



Parent Item Name: Cap

Start Date: 4/26/10

Required Date: 4/27/10

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	41.6050	1.0105			



6061-T6 Bar .500 x 6.00

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT05

41.605

110912

1.605

112567

40

*W/04/20*

1.0105

DART AEROSPACE LTD		Work Order: 58148
Description: CAP		Part Number: D3262-5
Inspection Dwg: D3262-5 Rev: <del>D</del> New Rev. E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø5.005	+0.010/-0.000	5.005	✓			
0.080	±0.010	0.079	✓			TYP
0.33	±0.030	0.3285	✓			
Ø0.70 x 45°	±0.010 / ±1/2°	0.075" x 45°	✓			Chamfer
0.250	±0.010	0.248	✓			
0.45	±0.030	0.438	✓			
Ø0.875	±0.010	0.875	✓			2PL
R0.063	±0.010	0.063	✓			
Ø5.165	±0.010	5.164	✓			REF
3.25	±0.030	3.247	✓			REF
9/16-18UNF-3B	N/A	9/16-18UNF-3B	✓			
3/4-16UNF-3B	N/A	3/4-16UNF-3B	✓			
0.091	+0.007/-0.008	0.094	✓			
Ø0.696	+0.007/-0.008	0.696	✓			
Ø0.588	+0.005/-0.000	0.590	✓			
0.101	+0.008/-0.007	0.106	✓			
Ø0.882	+0.008/-0.007	0.882	✓			
Ø0.771	+0.005/-0.000	0.775	✓			
30°	± 1/2°	30°	✓			
45°	± 1/2°	45°	✓			

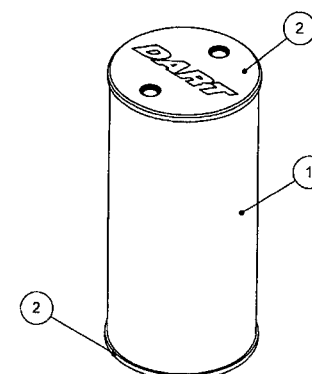
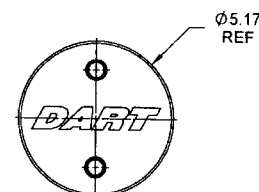
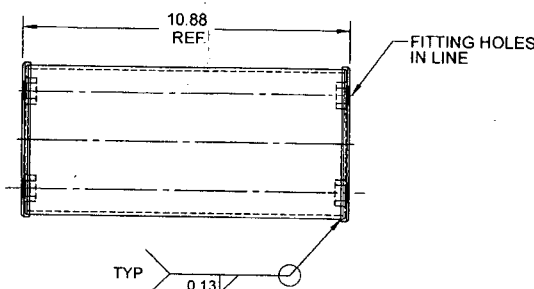
Measured by: DJP
Date: 10/04/27

Audited by: [Signature]
Date: 10-04-27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



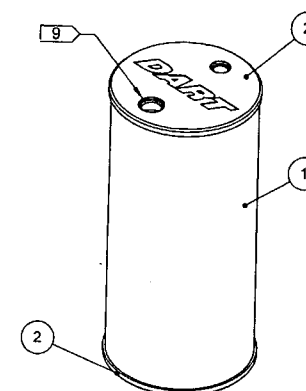
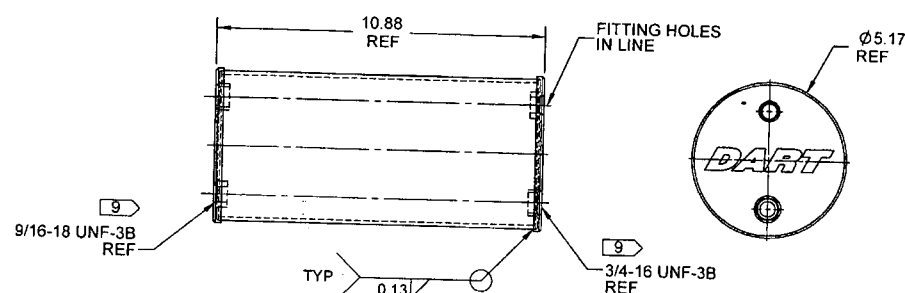
# D3262-041 CANISTER ASSEMBLY

**RELEASED**  
2010-05-07

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 2.51 lbs
  - 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

DESIGN	RF	DART AEROSPACE LTD	REV. E
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 5
CHECKED	RF	D3262	SCALE
MFG. APPR.	RF	FUEL PURGE CANISTER	NTS
APPROVED	RF		
DE APPR.	RF		
DATE	10.05.03		

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



**D3262-043 CANISTER ASSEMBLY**

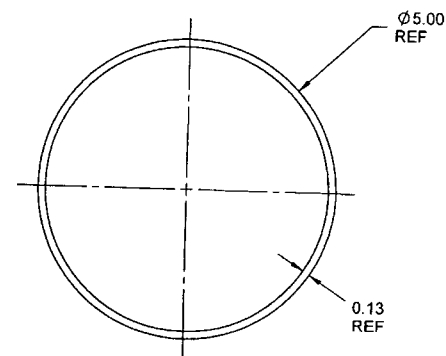
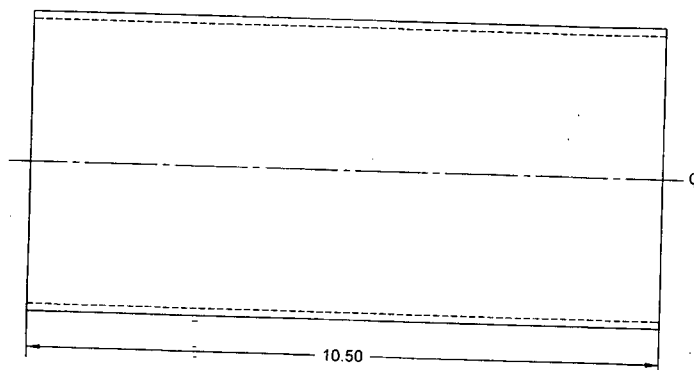
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

**RELEASED**  
2010-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D3262</b>	REV. E
MFG. APPR.	RF		SHEET 2 OF 5
APPROVED	RF	TITLE <b>FUEL PURGE CANISTER</b>	SCALE
DE APPR.	RF		NTS
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also  
3848



D3262-1 TUBE

**NOTES:**

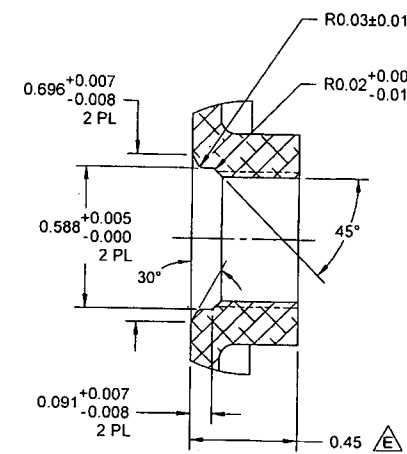
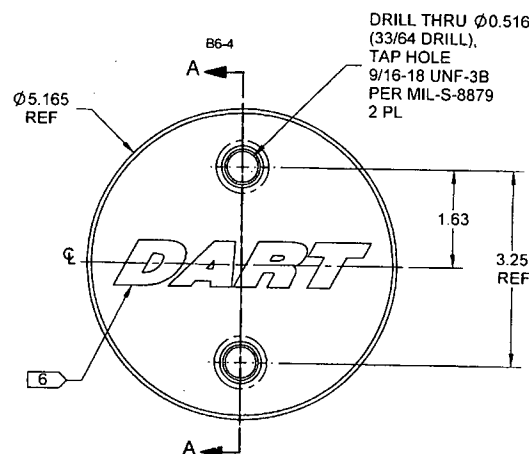
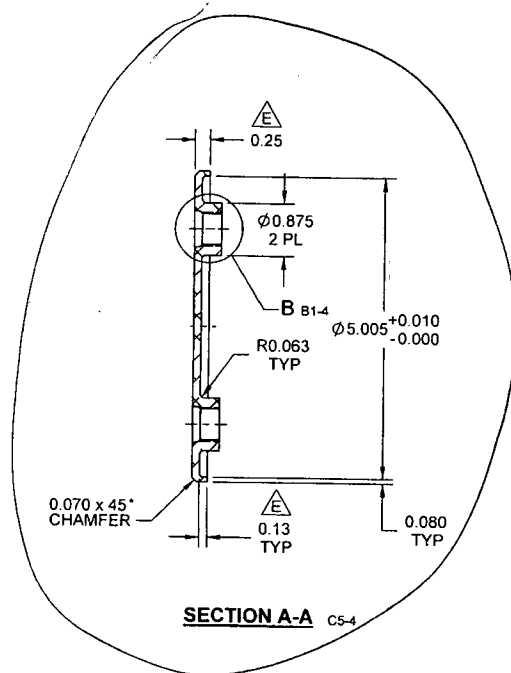
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

**RELEASED**  
2010-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3262</b>
MFG. APPR.	<i>[Signature]</i>	REV. E
APPROVED	<i>[Signature]</i>	SHEET 3 OF 5
DE APPR.	<i>[Signature]</i>	TITLE <b>FUEL PURGE CANISTER</b>
DATE	10.05.03	SCALE NTS

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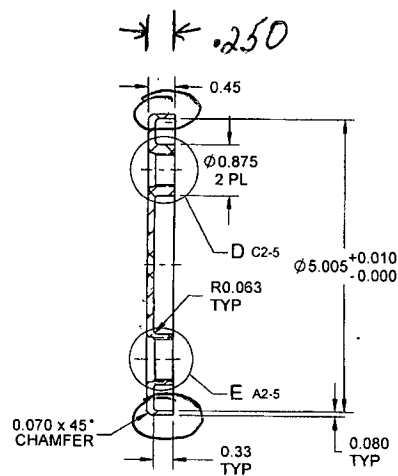


# NOTES:

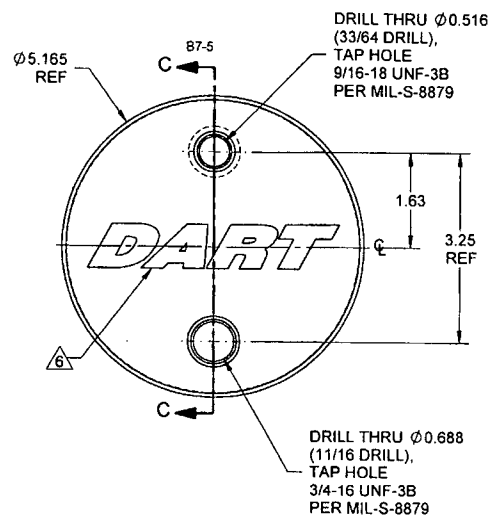
- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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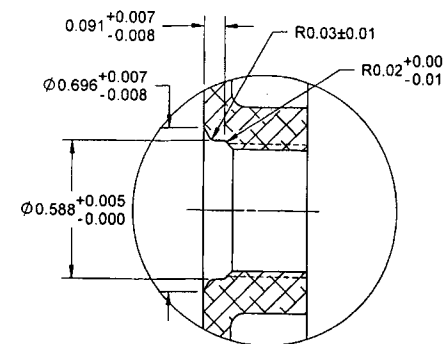
RELEASED  
2010-05-07  
AN



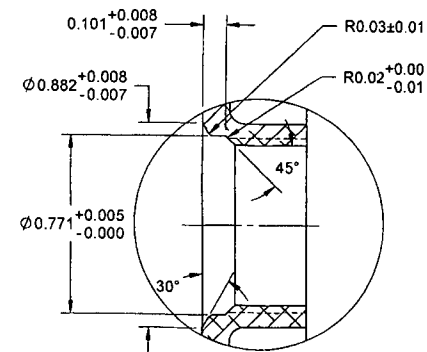
**SECTION C-C** D5-5



**D3262-5 CAP**



**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
SCALE 2X

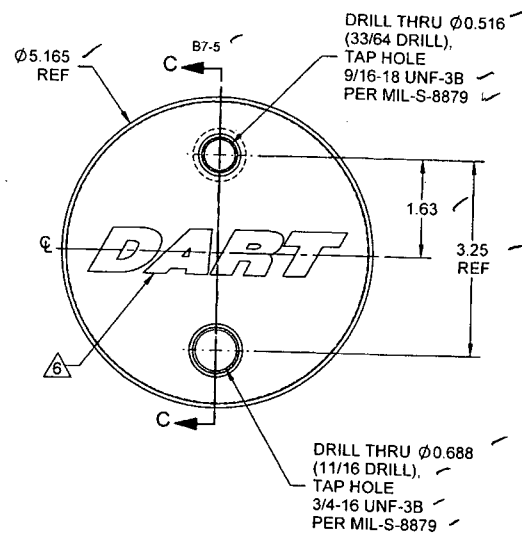
**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.29 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO. <b>D3262</b>	REV. D
MFG. APPR.	<i>RF</i>	SHEET 5 OF 5	
APPROVED	<i>RF</i>	SCALE	
DE APPR.	<i>RF</i>	TITLE <b>FUEL PURGE CANISTER</b>	
DATE	<b>09.12.30</b>	NTS	

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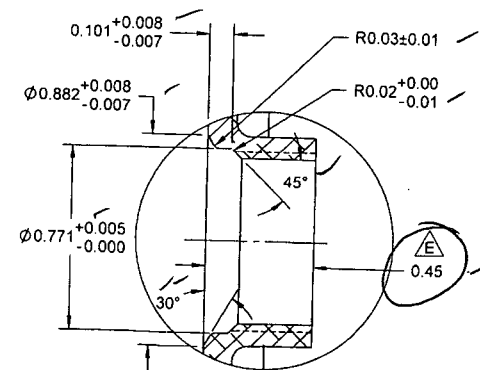


Technical drawing of a mechanical part (Fig. 1) showing a cross-section with dimensions and tolerances. The part has a circular outer profile and a rectangular inner profile. Dimensions include diameters (0.091, 0.696, 0.588), radii (R0.03, R0.02), and angles (45°, 30°). Tolerances are specified for several dimensions. A surface texture symbol (E) is shown on the right.

Dimensions and Tolerances:

- Top horizontal dimension:  $0.091^{+0.007}_{-0.008}$
- Left vertical dimension:  $\varnothing 0.696^{+0.007}_{-0.008}$
- Bottom left vertical dimension:  $\varnothing 0.588^{+0.005}_{-0.000}$
- Top right radius:  $R0.03 \pm 0.01$
- Bottom right radius:  $R0.02^{+0.00}_{-0.01}$
- Angles:  $45^\circ$  and  $30^\circ$
- Surface texture symbol:  $\triangle E$  with value 0.45

**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
**SCALE 2X**

RELEASED  
2010-05-27

- |            |           |  |              |
|------------|-----------|--|--------------|
| DESIGN     | RF        | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | RF        | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>RF</i> | DRAWING NO.  | REV. E       |
| MFG. APPR. | <i>RF</i> | D3262  | SHEET 5 OF 5 |
| APPROVED   | <i>RF</i> | TITLE  | SCALE        |
| DE APPR.   | <i>RF</i> | <b>FUEL PURGE CANISTER</b>   | NTS          |
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